

D206-628-034

Dart Aerospace Ltd.

Date: Wednesday, 13/05/2009 11:28:45 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FLOAT STEP ASSEMBLY RH (206/407)
Job Number :	47933A		
Estimate Number :	11775		
P.O. Number :		Part Number :	D2842042
This Issue :	13/05/2009	Drawing Number :	D2842 REV B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	11	Drawing Revision :	B
Previous Run :	46698A	Material :	
Written By :		Due Date :	29/05/2009
Checked & Approved By :	<u>Jul 09-05-13</u>	Qty:	8 Um: Each
Comment :	Est Rev:D As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Step Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<u>345494</u>

Check Material for any Dents or Defects

Jul 09-05-15 8

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842

2-Drill D2842-1 using Jig DT8272 as per Dwg D2842

3-Deburr and bevel ends for welding

Jul 09-05-15 38
Jul 09-05-15 38
Jul 09-05-15

3.0	D2734	Step End Plate
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<u>343535</u>

Jul 09-05-15 8

Date: Wednesday, 13/05/2009 11:28:46 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 47933A

Part Number: D2842042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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4.0	D34591	Float Step Mounting Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

plate

Batch: 346864=1 346987=9

Pl 09-05-20 8

5.0	D34593	Float Step Mounting Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

plate

Batch: 346866=6 346988=10

Pl 09-05-20 8

6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs as per Dwg D2842

A/R AL Rod Batch: M11C130
~~M11C977~~ M11C972

2-Grind end cap weld flush

Pl 09-05-20 8

7.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

SAD 09-05-25 8

8.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/05/26 +824

9.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 09-05-26 (18)

Date: Wednesday, 13/05/2009 11:28:46 AM
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Process Sheet

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Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 47933A

Part Number: D2842042

Job Number:



Seq. #: Machine Or Operation: Description :

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(8X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-2 09/05/27

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.

SAD 09-05-27

(8X)

Weld end cap as per Dwg D2842.

A/R AL Rod Batch: M110130

2-Grind end cap weld flush.

09-05-28 8
09-05-28 8

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

RE 09-05-29

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/05/29 (8X)

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

M111472

START TIME:

11:50

OVEN TEMPERATURE:

3200

FINISH TIME:

12:20

FL 09/06/01

(8X)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL / UMO 09/06/02

16.0

NAS1329C3KB130

insert



Comment: Qty.: 3.0000 Each(s)/Unit Total: 24.0000 Each(s)

Insert

Pick:

Qty Part Number

Description Batch

3

NAS1329C3KB130Insert

M1100951 X 10

UMD SAD

M110117 X 14

Date: Wednesday, 13/05/2009 11:28:46 AM
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Process Sheet

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Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 47933A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

MS27039C107

screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

MS27039C1-07

Screw

m 111424

UMP
SAD 09-06-03 (8)

18.0

NAS1515H3L

WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description Batch

3

NAS1515H3L

WASHER

~~*m 111808*~~

UMP
SAD 09-06-03 (8)

19.0

AN960C10L

washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

AN960C10L

WASHER

m 111808

UMP
SAD 09-06-03 (8)

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: FINISHING 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: *m 1118013*

SAD/BR
09-06-03 (8)

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD/BR
09-06-03 (8)

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *PPD 48933*

9/8/10 (8)

Date: Wednesday, 13/05/2009 11:28:46 AM
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Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 47933A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/10 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

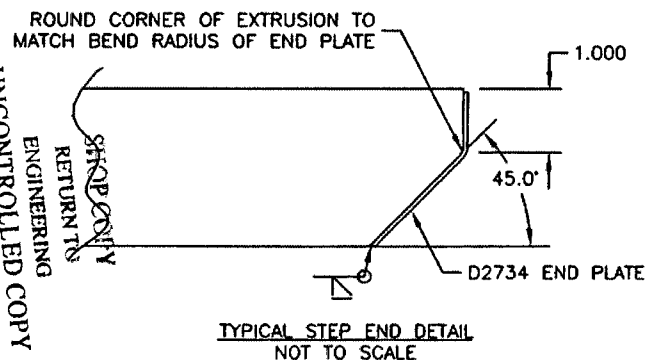
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA		REV. B
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2842	SHEET 1 OF 1	
DATE 05.09.23	TITLE 206L/407 FLOAT STEP ASSEMBLY		SCALE NTS	
A	98.10.13	NEW ISSUE		
B	05.09.23	RE-DESIGN, ADD D3459-1/-3		



QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

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